

Date: Thursday, 2/22/2007 2:58:34 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 30830		
Estimate Number	: 11139		
P.O. Number	: N/A	Part Number	: D32051
This Issue	: 2/22/2007 S.O. No. : N/A	Drawing Number	: D3205 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 28941	Material	: N/A
Written By	:	Due Date	: 3/15/2007 Qty: 8 Um: Each
Checked & Approved By	: <u>JA 07.02.23</u>		
Comment	: Est A 04.06.09 New issue KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M7075T73B2500X0325	7075-T73 Bar 2.5 x 3.25"
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Comment: Qty.: 0.3828 f(s)/Unit Total : 3.0626 f(s)

7075-T73 Bar 2.5 x 3.25"

Material: 7075-T73 (QQ-A-200/11 or QQ-A-250/12) or 2024-T3 (QQ-A-200/3 or QQ-A-250/4)

(M7075T73B2.500x03.25)

Identify for D3205-1

Batch: M102694

SD 07.03.30

8

107.95<sup>2.0</sup>

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blanks: 3.250" x 2.500" x 4.250" long Bar (+0.030/-0.000)

SD 07.03.30

8

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine D3205-1 as per Folio FA346 and Dwg D3205

Identify as D3205-1

Deburr and Tumble

JML/KD 07.03.30

8

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JML/KD 07.03.30

8

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 07/04/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LD Date: 07/04/05

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 2:58:34 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 30830

Part Number: D32051

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL

07/04/02

(8)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Note: Cover the thread hole for D3205-1 before powder coat.

FL

07/04/03

(8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Per 7/4/3 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Per 7/4/3 (8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/05 (8)

Job Completion



u 07/04/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

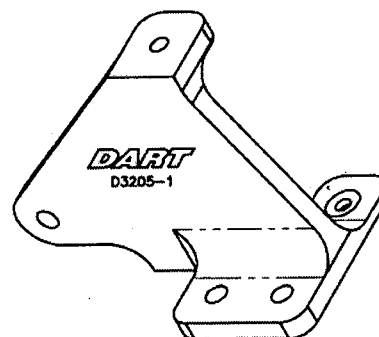
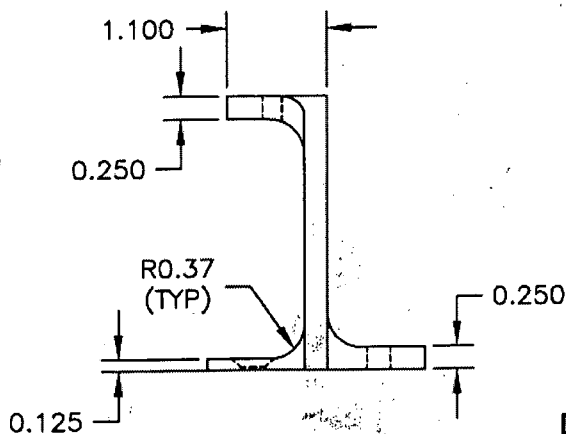
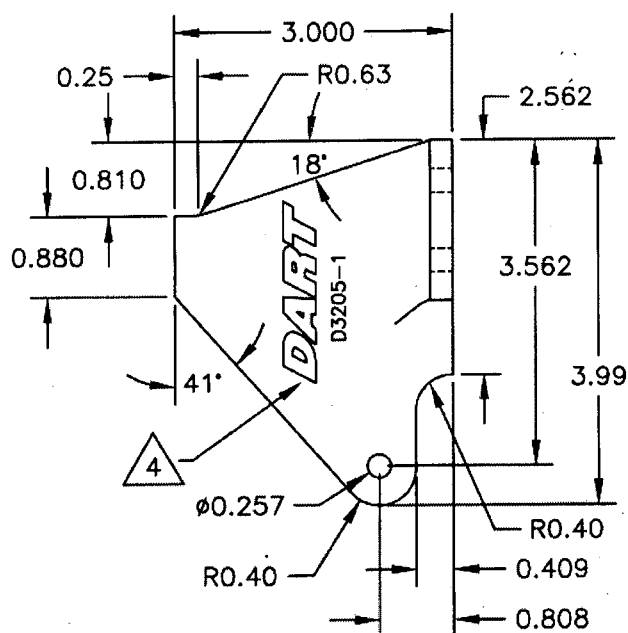
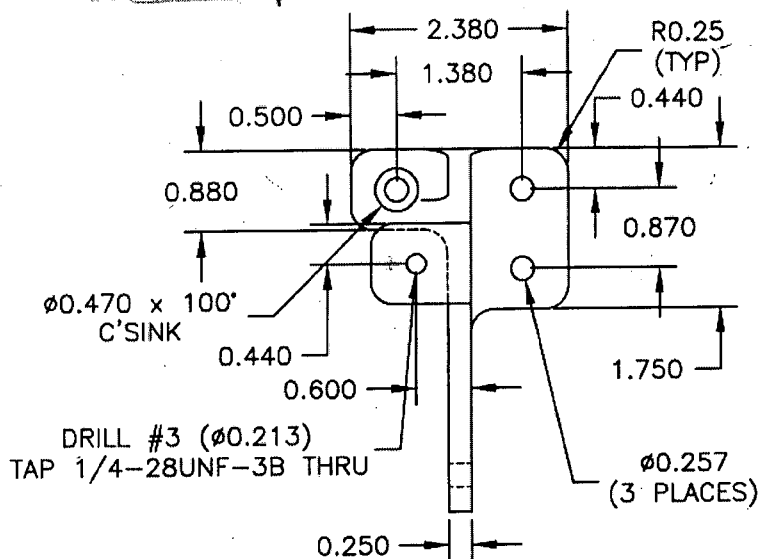
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3205	REV. A SHEET 1 OF 2
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED  
04.04.05 #



D3205-1 PEDAL BRACKET

NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 7075-T73 (QQ-A-200/11 OR QQ-A-250/12)  
OR 2024-T3 (QQ-A-200/3 OR QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE INCHES

SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 30830

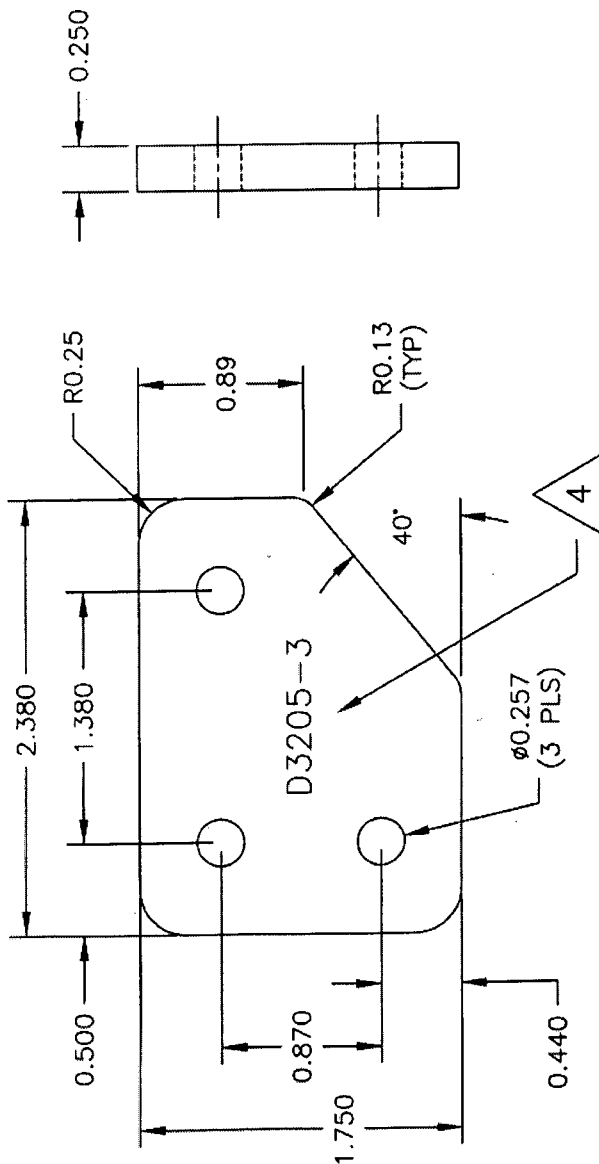
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DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3205	REV. A SHEET 2 OF 2
DATE 04.01.27		TITLE BRACKET	SCALE 1:1

RELEASED  
04.04.05 #



### D3205-3 BACK PLATE

- NOTES:
- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
  - 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
  - 3) FINISH: ALUMINUM BAR (M6061T6B)
  - 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 5) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
  - 6) ENGRAVE DART P/N AS SHOWN
  - 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 8) ALL DIMENSIONS ARE INCHES

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WORK ORDER  
NO. 30830

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 30830
<b>Description:</b> Pedal Bracket		<b>Part Number:</b> D3205-1
<b>Inspection Dwg:</b> D3205 <b>Rev:</b> A		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.100	+/-0.010	1.100	/			
0.250	+/-0.010	.253	/			
R0.37	+/-0.030	R.37	/			
0.125	+/-0.010	.126	/			
0.250	+/-0.010	.253	/			
2.380	+/-0.010	2.379	/			
1.380	+/-0.005	1.378	/			
0.500	+/-0.005	.499	/			
0.880	+/-0.010	.880	/			
Ø0.470 x 100°	+0.005/-0.000	Ø.470 x 100°	/			
0.440	+/-0.005	.444	/			
0.600	+/-0.005	.595	/			
1/4-28UNF-313	N/A	1/4-28UNF	/			
0.250	+/-0.010	.242	/			
Ø0.257	+0.005/-0.000	Ø.258	/			
1.750	+/-0.010	1.752	/			
0.870	+/-0.005	.871	/			
0.440	+/-0.005	.438	/			
R0.25	+/-0.030	R.25	/			

<b>Measured by:</b> SD	<b>Audited by:</b> SD	<b>Prototype Approval:</b> N/A
<b>Date:</b> 07.03.30	<b>Date:</b> 07.03.30	<b>Date:</b> N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	05.02.17	New Issue	KJ/JLM	[Signature]